

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025199**Date Inspected:** 03-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China

CWI Name:	N/A			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Visual Inspection after Blast

OBG Segment 13AW

This QA Inspector performed a preliminary random visual inspection on OBG Segment 13AW, after the grit blast of the interior components of the bottom plate, side plate, floor beam at panel point 119.65 to 120 of OBG Segment 14W. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

AT East side of PP119.65:

- Seg3013D: Section AY2 [C4 (of weld map)] - RS web to Flange - grinding notch observed.
- FB3194A: Base metal depression (of dia approx 75mm x 5mm deep) observed on X4157A stiffener plate of FB3194A.
- FB3194A: Base metal damage (dia 20mm x 5mm deep - approx) observed on X4157A stiffener plate of FB3194A.
- Seg3013D: Base metal damage (of dia approx 25mm x 6mm deep) observed on Bottom Panel (SA3168A) (between 2nd and 3rd RS stiffeners - from W13).

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- Seg 3013D: Base metal damage (between 3rd and 4th RS3439D stiffeners - from KP3016A and at east side of FB3194A, near FB to SP weld) observed on SP3101A.

AT West side of PP120:

- Seg3013B: Base metal damage (of approx 20mm x 5mm deep) observed on Bottom Panel (SA3168A) (between 2nd and 3rd RS stiffeners - from W13).

- Seg3013B: Base metal damage (of approx 20mm x 5mm deep) observed on Bottom Panel (SA3168A) (between 2nd and 3rd RS stiffeners - from W13).

AT East side of PP119+1500):

- Seg3013F: Grinding marks observed at FB to SP weld near area(at I-rib on SP to FB) at 6th to 10th RS stiffeners on SP (from KP end)..

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
Reviewed By:	Patel,Hiranch	QA Reviewer
